

Date: Thursday, 19/03/2009 11:05:44 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: SPRING		
<b>Job Number</b>	: 46580						
<b>Estimate Number</b>	: 10497						
<b>P.O. Number</b>	:			<b>Part Number</b>	: D2535		
<b>This Issue</b>	: 19/03/2009 <b>S.O. No.</b> :			<b>Drawing Number</b>	: D2535 REV. A		
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	: N/A		
<b>First Issue</b>	: / / <b>Type</b> : PURCHASED PARTS			<b>Drawing Revision</b>	: A		
<b>Previous Run</b>	: 45389			<b>Material</b>	:		
<b>Written By</b>	:			<b>Due Date</b>	: 15/04/2009		
<b>Checked &amp; Approved By</b>	: <u>JUL 09 03.19</u>			<b>Qty:</b>	100		
<b>Comment</b>	: Est. A99.04.19 New Issue (From hand written IPP) DM			<b>Um:</b>	Each		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>8429</u>	<u>C Log 03/20</u>
		Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring	(100)
2.0	D2535P	Spring	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) SPRING	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached	<u>SS 09/03/31</u> (X100)
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Check dims to dwg	<u>S 09/04/01</u> (X100) counter
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST 504</u>	<u>SS 09/04/01</u> (X100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 46580

Part Number: D2535

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



09/04/02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mf 09-04-01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

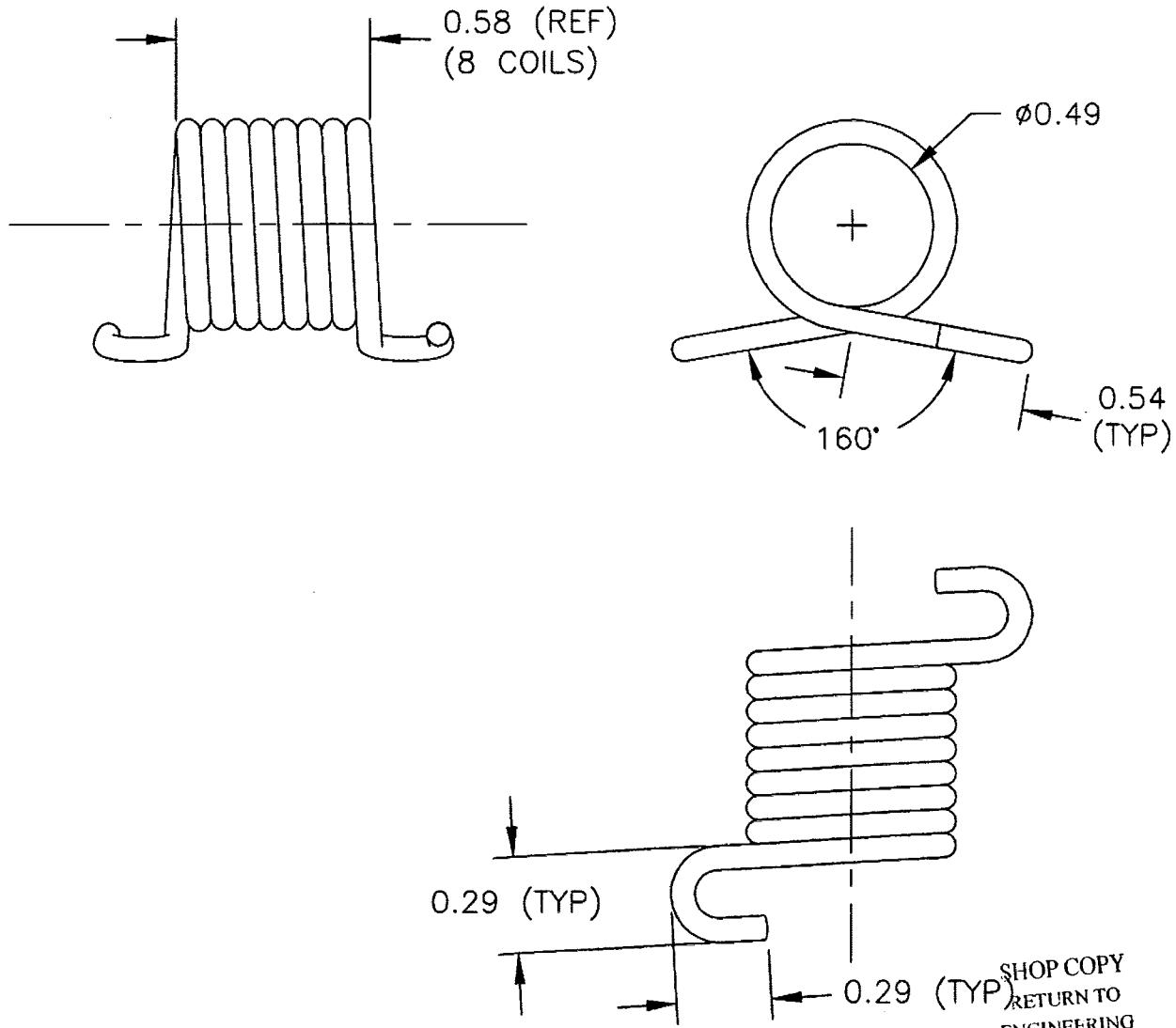
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>JM</i>	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08		TITLE SPRING SPEC CONTROL	SCALE 2:1
A	99.04.08	NEW ISSUE	

**RELEASED**  
99.05.11 KE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *46580*

**SPECIFICATION CONTROL DRAWING**

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL Ø0.070

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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## CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace	DATE: 3/30/2009
PART/DRAWING #: D2535P	PO # 8429
SPRING DESCRIPTION: Torsion Spring	QUANTITY: 100

S 02/01/01

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	yes	
Material diameter	0.070"	0.072"	As per last made
Coil I.D.	.490"	.483 / .490	Min/Max.
Number of Coils	8 ref.	yes	
Free Length			
Helix	RHW	yes	
End type	as per drawing	yes	

### COMMENTS

Mill Certificate attached: available upon request

Material Heat Number:

Inspected by:

*Jeremy Burrowes*